



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3912-5
Job Sheet 179727



Part No: D3912-5

Job Qty: 12 ea

Part Name: Eyebolt Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: new issue DD 09.11.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		7/18/18	0.00	0.00	Start Up Waterjet		SE 18/07/07
100	Waterjet	12 pcs		7/18/18	0.04	0.72	Waterjet1		SE 18/07/07
120	QC	12 pcs		7/18/18	0.00	0.00	QC8		38
130	Packaging	12 pcs		7/18/18	0.00	0.00	Packaging3	5/002	9-88
140	QC21-SA	12 Ea		7/18/18	0.00	0.00	QC21		JUL 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.6150 sf (.05125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	1	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0,131	Diameter
2	Eyebolt Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0,259	Diameter
3	Eyebolt Plate	0.380Inches + 0.030 - 0.003	0.410 0.377	0,385	
4	Eyebolt Plate	1.500Inches ± 0.010	1.510 1.490	1,502	
5	Eyebolt Plate	0.500Inches ± 0.010	0.510 0.490	0,500	Pitch
6	Eyebolt Plate	3.150Inches ± 0.030	3.180 3.120	2,154	
7	Eyebolt Plate	0.375Inches ± 0.010	0.385 0.365	0,378	
8	Eyebolt Plate	0.517Inches ± 0.010	0.527 0.507	0,520	
9	Eyebolt Plate	1.000Inches ± 0.010	1.010	1,001	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		DART AEROSPACE Container No: S089843 Part: D3912-5 Job No: 179727 Serial No/Batch: S089843 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/08/18 DART AEROSPACE 1278 Aberdeen Street Haverhill, MA 01830 TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Description Work Order Deviation					
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐			
Design ☐	Operator ☐	Bending ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concen ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/ ☐			
Material ☐	Use for Testing ☐	Cuffs ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

			0.990	
10	Eyebolt Plate	3.650Inches ± 0.030	3.680 3.620	3,656
11	Eyebolt Plate	1.500Inches $+ 0.020$ $- 0.000$	1.520 1.500	1,502
12	Eyebolt Plate	0.250Inches ± 0.030	0.280 0.220	0,254
13	Eyebolt Plate	2.000Inches ± 0.030	2.030 1.970	2,001
14	Eyebolt Plate	0.125Inches ± 0.010	0.135 0.115	0,115

Plex 6/21/18 7:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			